

Work Order ID 54528



Page 1

December 10, 2009 3:46:31 PM

Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 10/12/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 12/12/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-578-011 CHG005								
160	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

S1010104

for MF 09/12/30

C 8/10/29 (6)

S1010104

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: AVA

PO 10/01/05 (6)

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10-01-05

MF 10-01-05

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54528

Parent Item: D350-578-011

Parent Item Name: Bearpaw

Comments:

Start Date: 10/12/2009

Required Date: 18/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD416 *24 v* Purchased No



Washer

NAS 1149 D04635

AS.1 4.2.11 Po

1,933.000 144.0000



11/13/08

[Signature]

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1933

108161

329

110523

340

111279

101

111916

482

112314

681

16941

0

AN4-17A *12 v*



Bolt

Purchased No

160

Each

1,420.000 72.0000



12/29/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1420

105653

5

107321

10

109061

5

111758

400

112314

1000

11/17/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Qty: 6.00

Component Item ID/ Item Name	Replacemen Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	-----------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2182B-050	246	Manufactured	No			160	f	357.2160	15.0000	✓		
------------	-----	--------------	----	--	--	-----	---	----------	---------	---	--	--



Rubber Cushion

↳ measured
8/10/14

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 57.216

28042 7.33

30872 0.33

45405 49.556

Main Warehouse

ST410 300

52649 300

8.33 A

6.67 F

D2274 1240



Radius Block

Manufactured No

160 Each 217.0000 72.0000

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 217

52644 217

52.644

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-578-011

Parent Item Name: Bearpaw

Comments:

Start Date: 10/12/2009

Required Date: 18/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2432		Manufactured	No			160	Each	3.0000	12.0000			
-------	--	--------------	----	--	--	-----	------	--------	---------	--	--	--

206 (24") Bearpaw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3

30576

1

53432

2

D2438		Manufactured	No			160	Each	132.0000	36.0000			
-------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--

Clamp

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

105

46113

5

53221

100

Main Warehouse

ST456

27

52645

27

B54529 12X
10/12/23

B5

53221 21X

52645 10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D350-578-011



Parent Item Name: Bearpaw

Start Date: 10/12/2009

Required Date: 18/12/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2529 <i>12x</i> Washer		Manufactured	No		160	Each	922.0000	72.0000	<i>✓</i>	<i>12/12/09</i>	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

922

52745

922

160

Each

3,927.000

72.0000

52745

12/12/09 (6)

MS21042L4 *12x*



Nut

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3927

110507

184

111827

3743

15924

0

11/18/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

F1	49.03.03	ADD DEC 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
49.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING
ROLLED COPY
TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
54328
110912-6

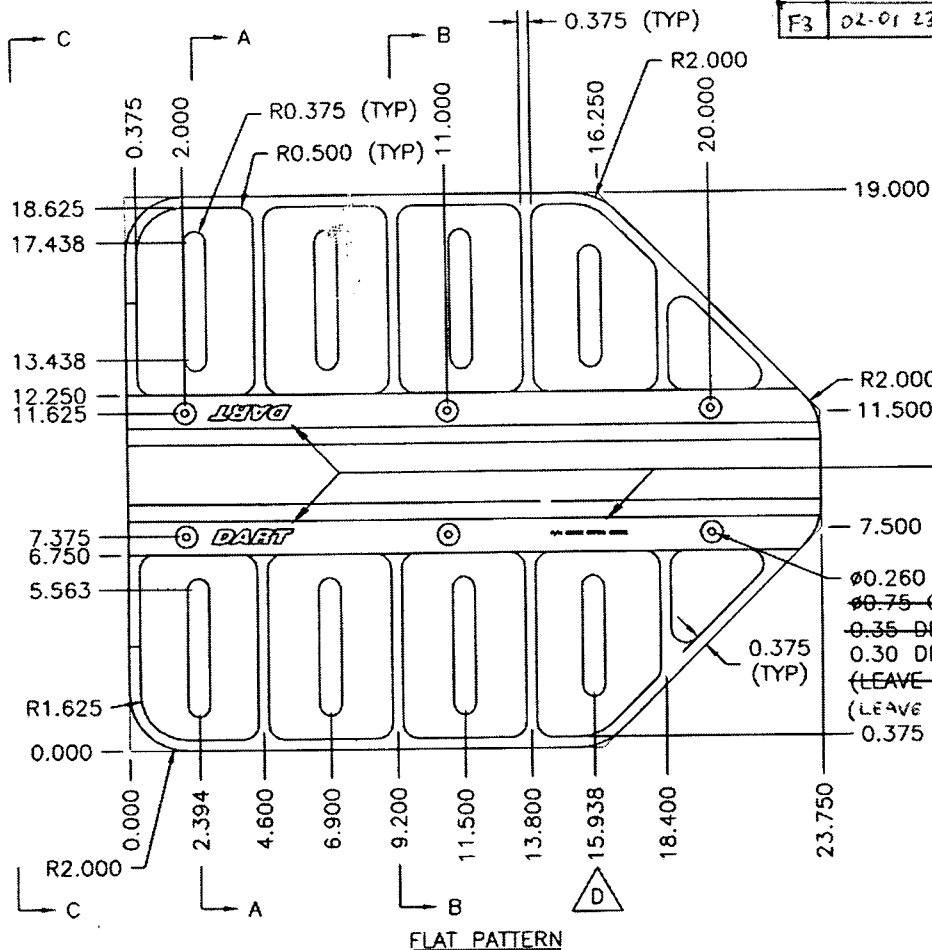


ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN		DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
KE		KE			
CHECKED		APPROVED		DRAWING NO.	
MM		JH		D2432	
DATE				TITLE	
98.05.12				BEARPAW	
				SCALE	
				1:6	
A		95.10.31	NEW ISSUE		
B		96.01.24	RE-DESIGN		
C		96.03.26	CHANGE BORE AND C'BORE DEPTH		
D		96.06.04	MOVE SLOT		
E		97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS		
F		98.05.12	CHANGE C'BORE, ADD B AND F P/N		

△ F2
△ F1
△ F
△ F1

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

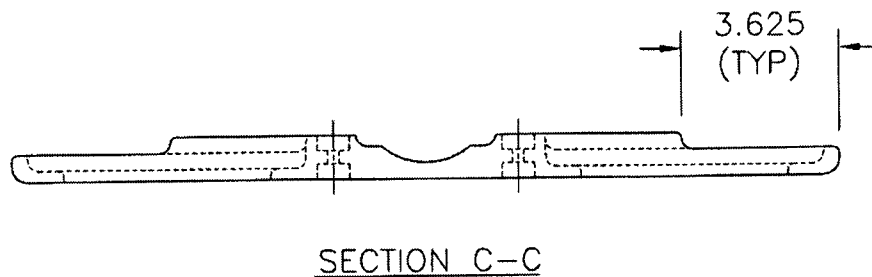
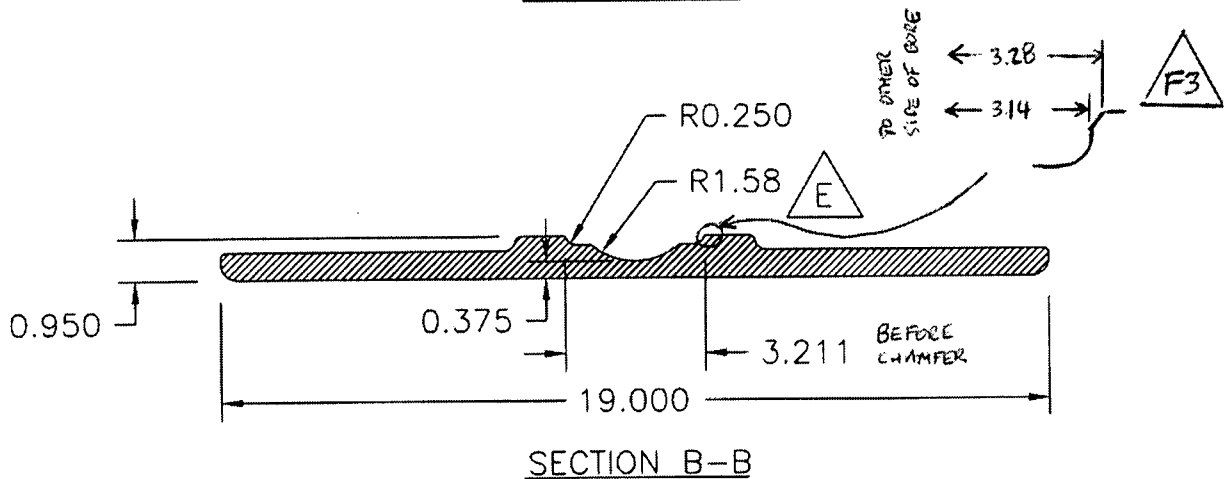
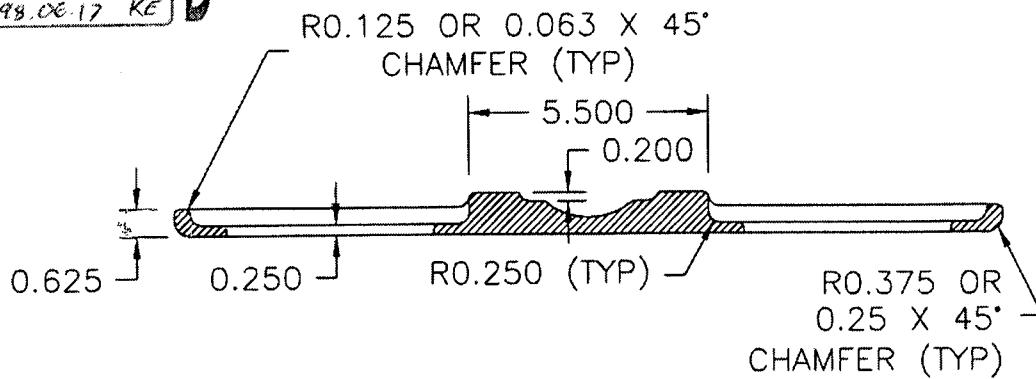
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NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



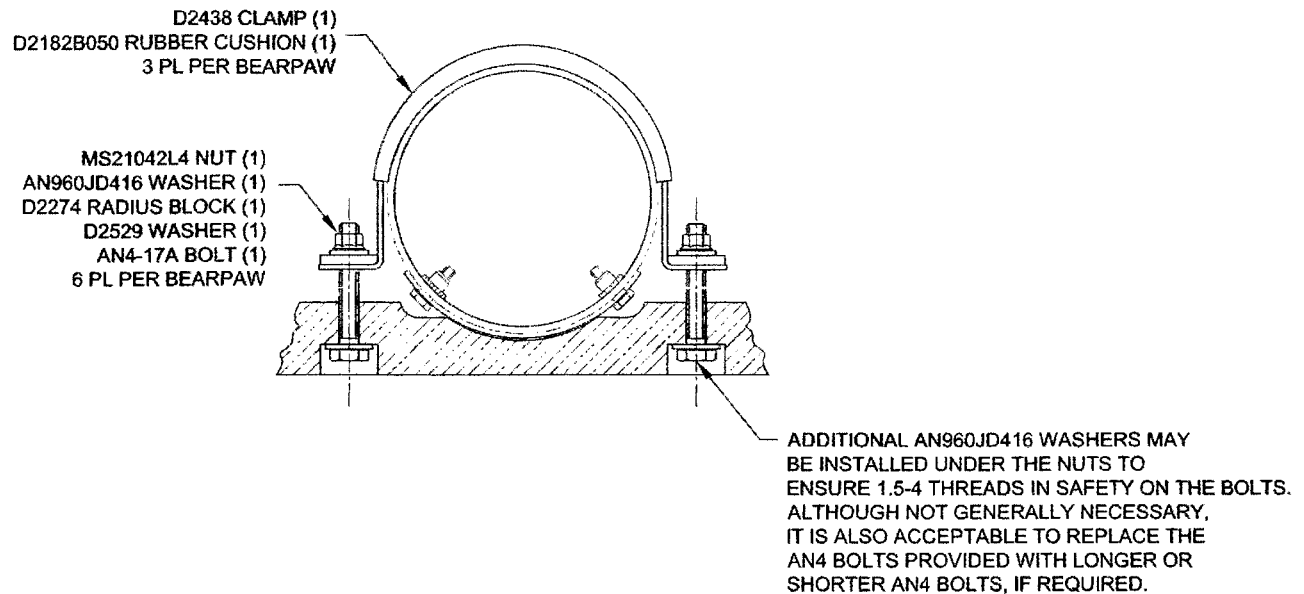
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Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
1		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)